

Date: Monday, 25/02/2008 7:43:48 AM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: NUT
Job Number	: 37585		
Estimate Number	: 11087		
P.O. Number	:	Part Number	: D31763
This Issue	: 25/02/2008 S.O. No. :	Drawing Number	: D3176 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11	Drawing Revision	: A
Previous Run	: 33223	Material	:
Written By	: <u>JLM 06.02.25</u>	Due Date	: 03/03/2008
Checked & Approved By	:	Qty:	15 Um: Each
Comment	: Est Rev:B Removed -1 05-11-29 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R1000	303 Round Bar 1.0"
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Comment: Qty.: 0.0525 f(s)/Unit Total: 0.7875 f(s)

Material: AISI 303 SS 1.00 round bar

Ref: Dart Spec: M303R1.000)

Batch: M107244

J.F. - 08/05/09 (16)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA287 & DWG D3176

2-Deburr

J.F. - 08/05/09 (16)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. - 08/05/09 (16)

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

1- Mill flats as per dwg D3176

2- Deburr

J.F. - 08/05/09 (16)

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Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/05/09 (16)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

RP. 08/05/09 (16)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 50 74

08/05/12 (16)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/14

Job Completion



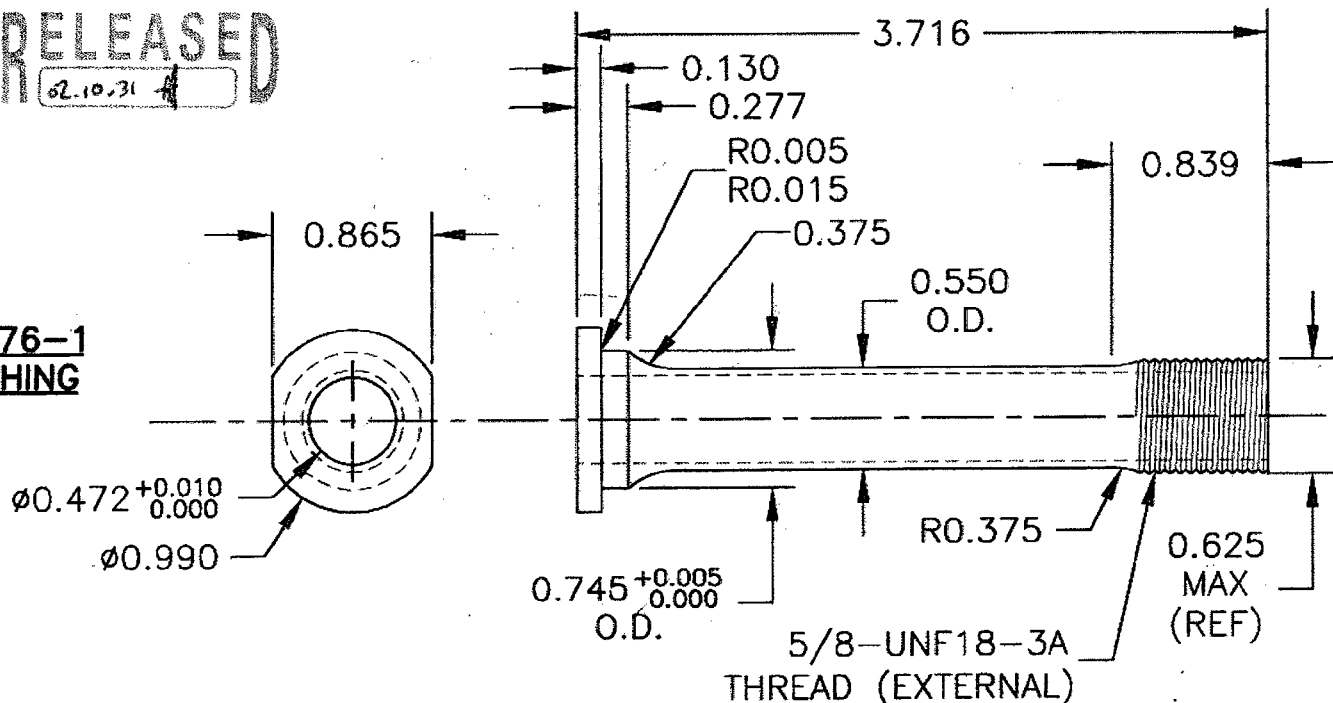
08/05/13



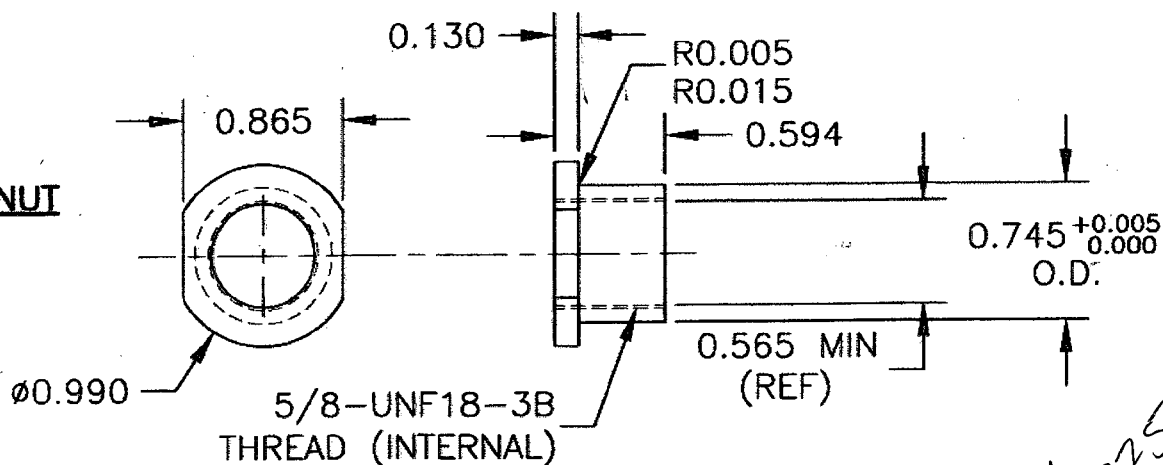
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3176	REV. A SHEET 1 OF 1
DATE 02.10.28		TITLE BUSHING / NUT	SCALE 1:1
A	02.10.28	NEW ISSUE	

RELEASED
02.10.31

**D3176-1
BUSHING**



D3176-3 NUT



D3176-1/-3

- 1) MATERIAL: AISI 303 S.S. (REF DART SPEC. M303R1.000)
- 2) THREADS PER MIL-S-7742
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) FINISH: NONE
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) D3176-1/-3 ARE MATING PARTS

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